



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4776-3

Job Sheet 180590



Part No: D4776-3

Job Qty: 20 ea

Part Name: Skidtube Clevis



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/10/18

Job Tracking No:

Due Date: 7/20/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D SHEET 2 IPP REV A: NEW ISSUE JFS 13/03/07 VERIFY BY: JLM IPP REV:B 13.09.26 AS PER REV.B DD VERF:JLM IPP REV:C AS PER REV. PC1 JFS 13/11/07 VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	7/20/18	7/20/18	0.00	0.00	Start Up Machining-3		
100	Bandsaw	20 pcs	7/20/18	7/20/18	0.00	0.36	Bandsaw1		DAS
110	CNC Vertical Machining	20 pcs	7/20/18	7/20/18	0.26	17.39	HAAS1-5		54
120	QC	20 pcs	7/20/18	7/20/18	0.00	0.00	QC2 Machining-3		9-89
130	QC	20 pcs	7/20/18	7/20/18	0.00	0.00	QC8 Machining-3		
140	HandFinish	20 pcs	7/20/18	7/20/18	0.00	0.53	HandFinish1		1/18 8/7/25
150	QC	20 pcs	7/20/18	7/20/18	0.00	0.00	QC7-4		5/18-07-25
160	Powdercoat	20 pcs	7/20/18	7/20/18	0.00	0.24	Powdercoat1		5/18-7-26
170	QC	20 pcs	7/20/18	7/20/18	0.00	0.00	QC3		5/18-7-26
180	Packaging	20 pcs	7/20/18	7/20/18	0.00	0.00	Packaging3-2		DAS 6
190	QC21-SA	20 Ea	7/20/18	7/20/18	0.00	0.00	QC21		9-89 21 AUG 01 2018

Part Op 100 - Cut Blank at 4.400"

Descriptions: 110 - 1-Machine per folio FB168

160 - START TIME: 9:30 OUT: 3:00 FINISH: 9:00. M138839.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X2.500	6061-T6 Bar 1.50 X 2.50	7.3400 ft (.367 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.500X2.500	7	24	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Skidtube Clevis	4.250Inches $\pm$ 0.030	4.280 4.220		
2	Skidtube Clevis	2.250Inches $\pm$ 0.030	2.280 2.220		
3	Skidtube Clevis	1.688Inches $\pm$ 0.010	1.698 1.678		
4	Skidtube Clevis	0.880Inches $\pm$ 0.030	0.910		

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐		☐	Temperature/Cure ☐	☐	Power Loss/Surge ☐
Design ☐	☐	Operator ☐		☐	Set-up ☐	☐	Folio/Program ☐
Doc/Data ☐	☐	Offset/Setup ☐		☐	BOM/Route ☐	☐	Grain ☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Pressure/Forced ☐	Broken/Damage/Defect ☐	☐	Weld ☐
Handling/Pre ☐	☐	Training ☐	☐	Bending ☐	Inspection Incomplete/Unqualified ☐	☐	Wrong Stock Pulled ☐
Material ☐	☐	Use for Testing ☐	☐	Centre Not Concentric ☐	Contamination ☐	☐	Out of Sequence ☐
Internal Transport ☐	☐	Poor Information ☐	☐	Cracks ☐	Countersink ☐	☐	Off-set ☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Crimp/Kink/Ripple/Wave ☐	Cut Too Short ☐	☐	Mislabeled ☐
LOA ☐	☐	Product Improvement ☐	☐	Cuffs ☐	Instructions Incomplete/Unclear ☐	☐	Fit/Function ☐
Substation ☐	☐	Process Improvement ☐	☐	Crushing ☐	Drill Holes ☐	☐	Misaligned/off center ☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	Heat Treat ☐			
Misidentified ☐	☐	Past Due ☐	☐	Wave/Twist in Tube ☐			
				OTHER : ☐			

			0.850	
5	Skidtube Clevis	0.510Inches + 0.010 - 0.000	0.520 0.510	
6	Skidtube Clevis	1.063Inches ± 0.010	1.073 1.053	
7	Skidtube Clevis	1.380Inches ± 0.030	1.410 1.350	
8	Skidtube Clevis	0.190Inches ± 0.030	0.220 0.160	
9	Skidtube Clevis	1.000Inches ± 0.030	1.030 0.970	
10	Skidtube Clevis	0.484Inches + 0.006 - 0.001	0.490 0.483	Diameter
11	Skidtube Clevis	0.500Inches ± 0.030	0.530 0.470	
12	Skidtube Clevis	0.550Inches ± 0.030	0.580 0.520	
13	Skidtube Clevis	3.150Inches ± 0.010	3.160 3.140	
14	Skidtube Clevis	1.130Inches ± 0.030	1.160 1.100	
15	Skidtube Clevis	0.688Inches ± 0.010	0.698 0.678	
16	Skidtube Clevis	0.397Inches + 0.006 - 0.001	0.403 0.396	Diameter
17	Skidtube Clevis	1.813Inches ± 0.010	1.823 1.803	
18	Skidtube Clevis	0.190Inches ± 0.030	0.220 0.160	Radius
19	Skidtube Clevis	0.130Inches ± 0.030	0.160 0.100	Radius
20	Skidtube Clevis	0.440Inches ± 0.030	0.470 0.410	Radius
21	Skidtube Clevis	0.125Inches ± 0.010	0.135 0.115	
22	Skidtube Clevis	0.380Inches ± 0.030	0.410 0.350	
23	Skidtube Clevis	0.750Inches ± 0.030	0.780 0.720	
24	Skidtube Clevis	0.250Inches ± 0.030	0.280 0.220	Radius

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S095630



Part: D4776-3

Job No: 180590

Serial No/Batch: S095630

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 07/24/18